

Work Order ID 77137

77137

Page 1

November-25-11 3:14:18 PM

Item ID: D3908-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Assembly, Aft
 Start Date: 25/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3908	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg TRIM RIVETS 1.185" LONG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

EP 11/12/06 (2)

EP 11/12/06 (2)

8 11/12/06

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>471</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
11-12-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November-25-11 3:14:22 PM

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Work Order ID: 77137

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Parent Item: D3908-041

D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV B:

As per Rev B 10-04-06 VERIFIED BY:DD

IPP Rev:C as per PC1

10.05.27 DD verf:EC

IPP Rev:D per ECN10-581

10.05.28 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 *D2690-6* Lanyard Assembly		Manufactured	No			100	Each	22.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				22					
				73324				2					
				74515				20					
D3908-1 *D3908-1* Lug Plate, Aft Crosstube		Manufactured	No			100	Each	5.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				5					
				73539				5					
D3908-3 *D3908-3* Stud Receiver, Lower		Manufactured	No			100	Each	11.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				11					
				68260				1					
				76283				10					

EPB 11/12/06

EPB 11/12/06

377 100 (34)

EPB 11/12/06

2

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Parent Item: D3908-041

D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3908-5 Manufactured No

100 Each 13.0000 1 2

D3908-5

Eyebolt Stud

**

EP 11/12/06

Location

Loc Qty

Loc Code

GA

1

57428

1

ST090

12

59670

2

76284

10

D3910-1 Manufactured No

100 Each 25.0000 1 2

D3910-1

Crosstube Lug

**

EP 11/12/06

Location

Loc Qty

Loc Code

ENG

2

70160

2

st507

23

73527

23

D4091-1 Manufactured No

100 Each 7.0000 1 2

D4091-1

Mounting Lug

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST460

7

69605

7

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C12A Purchased No

100

Each

102.0000

2

4

AN3C12A

Bolts

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST351

102

117514

4

118112

5

118422

17

118451

22

118838

4

119510

50

4

AN4C13A Purchased No

100

Each

32.0000

1

2

AN4C13A

BOLT

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST357

32

118838

32

2

MS17984-C413 Purchased No

100

Each

19.0000

1

2

MS17984-C413

PIN, QUICK RELEASE

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST315

19

114340

1

118612

2

119307

6

119623

10

2

W/O:		WORK ORDER CHANGES					
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D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

4/118
MS20615-4M20 Purchased No
MS20615-4M20
RIVET

100 Each 214.0000 6 12

**

EP 11/12/06

Location

Loc Qty

Loc Code

GA	214
117071	30
118571	34
119546	50
119638	100

M118077
(12x)

MS21043-3 Purchased No
MS21043-3
Nut

100 Each 959.0000 2 4

**

EP 11/12/06

Location

Loc Qty

Loc Code

FG	72
103691	72
ST301	887
118077	1
118614	469
118686	167
119758	250

4

8 MS21043-4 Purchased No
MS21043-4
Nut

100 Each 1,457.000 1 2

**

EP 11/12/06

Location

Loc Qty

Loc Code

FG	40
104603	40
ST301	1417
117793	5
118686	470
119309	442
119546	500

1

M119546 (12)

November-25-11 3:14:22 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

100

Each

5,899.000

4

8

NAS1149C.0332R

Washer

Location

Loc Qty

Loc Code

ST297

5899

118354

783

119124

120

119736

4996

EP 11/12/06

8

NAS1149C0432R

Purchased

No

100

Each

4,362.000

2

4

NAS1149C.0432R

Washer

Location

Loc Qty

Loc Code

ST297

4362

117291

3362

119124

1000

EP 11/12/06

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

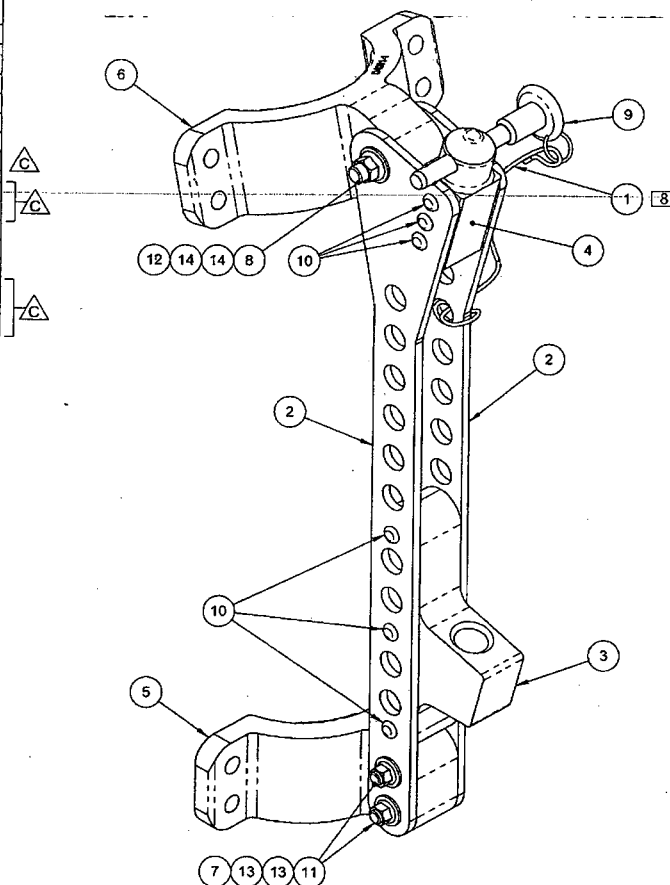
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77137 M.C.J
11/11/25

RELEASED
2010-05-28
AW

C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 2: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. D3908	REV. C
CHECKED	JPH	SHEET 1 OF 5	
MFG. APPR.	JPH	TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
APPROVED	JPH	DATE 10.05.27	
DE APPR.	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

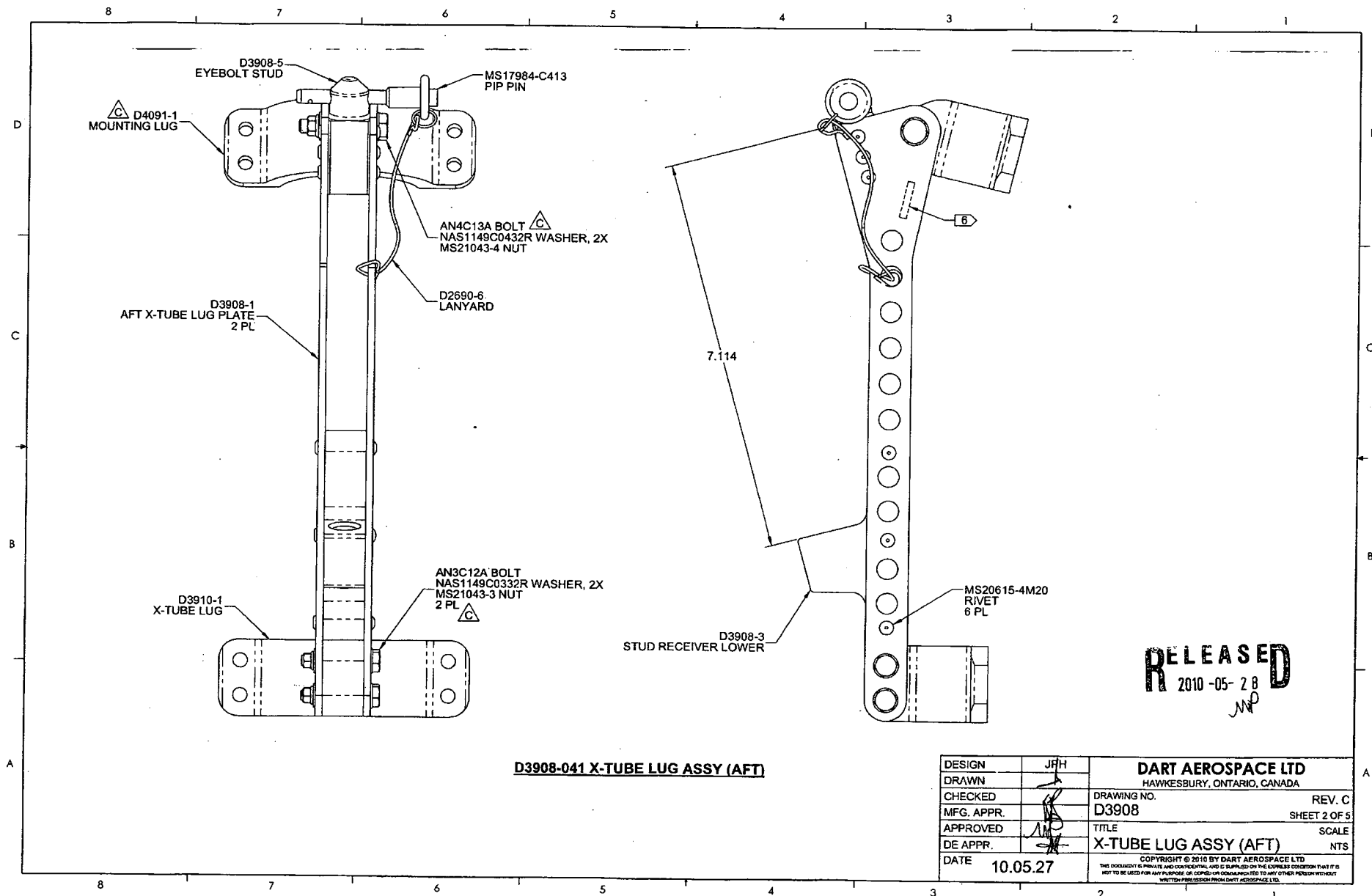
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27137



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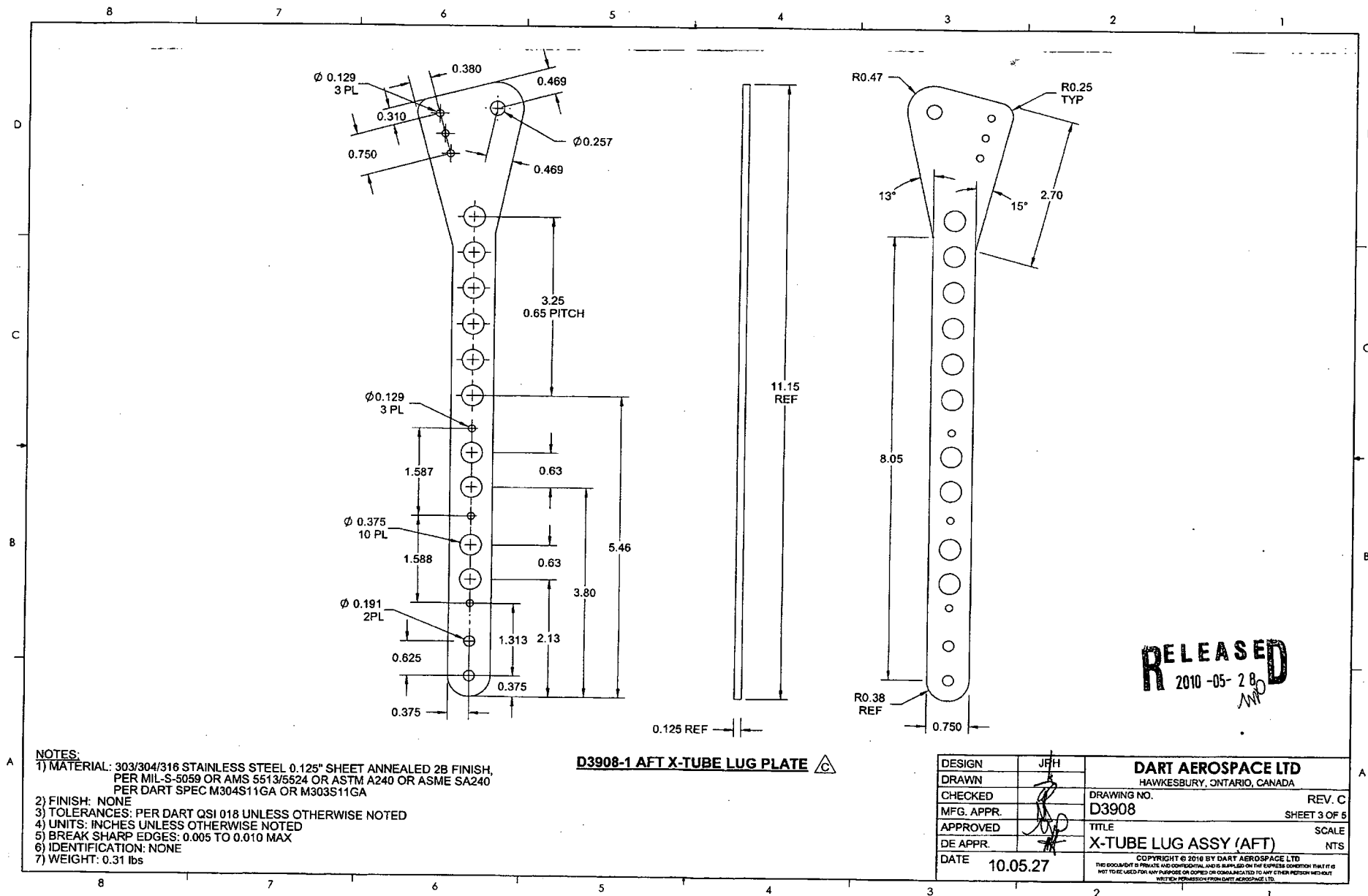
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47137



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

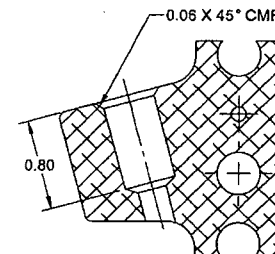
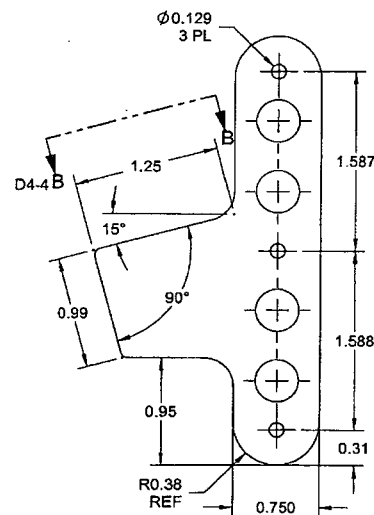
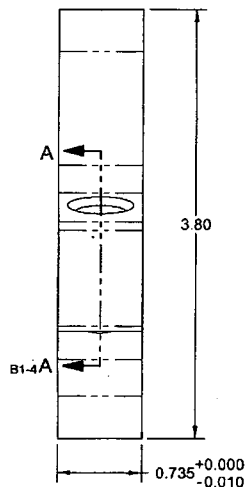
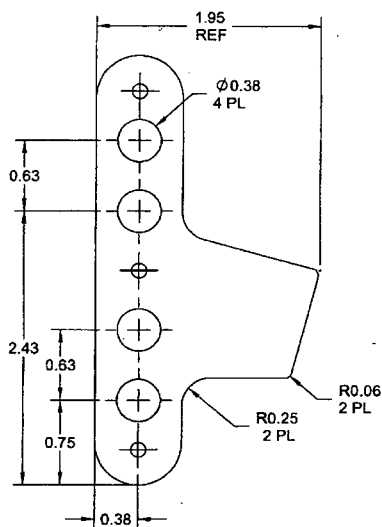
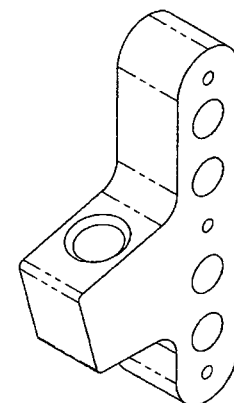
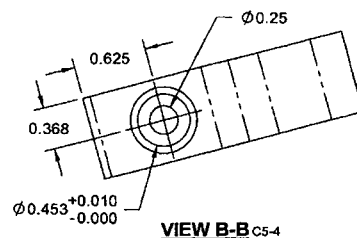
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NOTE: Date & initial all entries

77137



D3908-3 STUD RECEIVER LOWER

SECTION A-A B6-4

RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.05.27		

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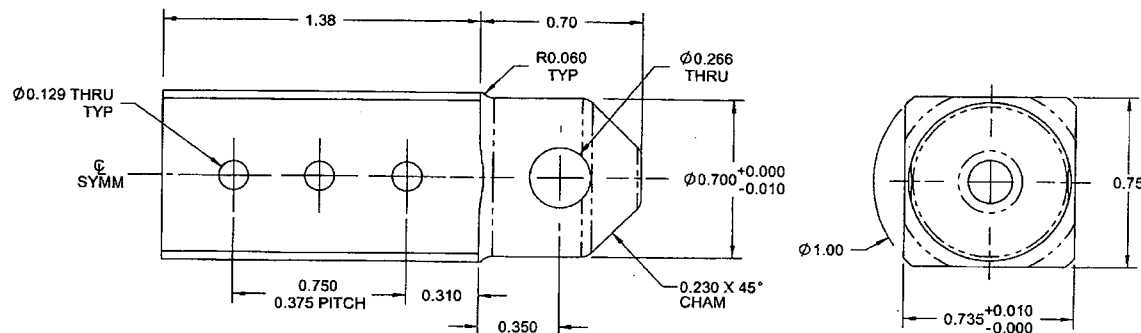
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D3908-5 EYEBOLT STUD

RELEASED
2010-05-28
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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